



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3220-041
Job Sheet 170822



Part No: D3220-041

Job Qty: 6 ea

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 1/30/18

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-06 JLM IPP: B 06.11.15 waterjet EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/29/18	0.00	0.00	Start Up Waterjet		Se 18/01/25
100	Waterjet	6 pcs		1/29/18	0.10	0.65	Waterjet1		Se 18/01/25
110	QC	6 pcs		1/29/18	0.00	0.00	QC2 Waterjet-1		Se 18/01/25
120	QC	6 pcs		1/29/18	0.00	0.00	QC8-2		38
130	Small Fab	6 pcs		1/29/18	0.00	0.43	Small Fab-3		9-88 DAS
140	QC	6 pcs		1/29/18	0.00	0.00	QC5		38
150	HandFinish	6 pcs		1/29/18	0.00	0.45	HandFinish1		2018/01/31 JLM
160	QC	6 pcs		1/29/18	0.00	0.00	QC3		9-88
170	Small Fab	6 pcs		1/30/18	0.00	0.43	Small Fab-3		DAS
180	QC	6 pcs		1/30/18	0.00	0.00	QC5		38
190	Packaging	6 pcs		1/30/18	0.00	0.00	Packaging3-1		9-88
200	QC21-SA	6 Ea		1/30/18	0.00	0.00	QC21		DAS

Part Op 100 - 1-Cut D3220-1 as per Dwg D3220 Dwg Rev: **B**
Descriptions: 130 - 1-Deburr 2-C'sink D3220-1 as per Dwg D3220
170 - Assemble D3220-041 doubler as per Dwg D3220

21 FEB 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	4.1556 sf (.6926 ea)	90-Start up Operation	
MS20426AD3-3	Rivet 5018535	48 Ea (8 ea)	170-Small Fab	
MS21059L4	Nutplate	24 Ea (4 ea)	170-Small Fab	

FM137736-3 3x

5016885 (1x)

5006920 20x

5032209 (5.16) Part Specifications

Specifications could not be found.

Plex 1/19/18 2:38 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ " Fab ☐ ng ☐ ite ☐	Water Jet ☐ Engineering ☐ Prod. Eng. Coord. ☐ Quality ☐ Rec/Store/Packaging ☐ Other ☐ Supplier ☐																				
 S035718 Doubler Assembly		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																					
PART NO: D3220-041 Original Serial #: S035718 Revision: Operation: Start up Operation Change No:		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																					
01/25/18 Job No: 170822		FACTORY <table style="width:100%;"> <tr> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>		☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Dimensions	☐ Grain	☐ Over/Under tolerance	☐ Weld	☐ Part Incorrect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Part Moved	☐ Off-set	☐ Drawing	☐ Mislabeled	☐ Finish	☐ Fit/Function	☐ Misread	☐ Misaligned/off center	☐ Turning Sequence
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